

304 .375

Work Order ID 159303

159303

Page 1

Friday, April 07, 2017 12:12:17 PM

Item ID: D5338-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bushing

Start Date: 4/13/2017 Start Qty: 40.00

40

Cust Item ID:

Required Date: 4/18/2017 Req'd Qty: 40.00

40

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: DAS Date: APR 07 2017 Tooling: _____ Date: _____

Run Start

NR1

QC: 21 Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5338	A

100

0.00

100

Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

3.33

Turn per Folio FB429 and Dwg D5338 Deburr BOTH ENDS

FOLIO REV: 2ADWG REV: A

DAS

49

9-89

DAS

45

9-89

DAS

45

9-89

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

120

0.00

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

DAS

08

9-89

P.T.O.

DQA:

Date:

2017-05-25



QA Closed:

Date:

MAY 16 2017

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>159303</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. <u>D5338-1</u>		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. <u>17-6418</u>		Scrap ☒		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: <u>17-04-17</u>		Step #: <u>100</u>		QTY Effective: <u>43</u>			MRB (QSI042) Approval		
							DAS 9 9-89 <u>17-04-17</u>		
Description Work Order Deviation				Disposition				Completed By	
Wrong material use. 303 was used instead of 304.				Scrap and replace with 304 material				DAS 49 <u>17-4-17</u> 9-89	
2c. Did not use material called up on Bom mate , but draw drawing says that 303/304/316 is acceptable.				(does part 303 to be welded and 303 can't be welded)				Lead hand / Supervisor Approval Verification	
				Add memo on work order to use 304 only. <u>17/04/17</u>				DAS 14 <u>17/04/17</u> 9-89	
								QC / QA Coordinator Approval	
								DAS 9 9-89 <u>17-04-17</u>	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☒	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	☒ Instructions Incomplete/Unclear	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Work Order ID 159303***159303***

Page 2

Friday, April 07, 2017 12:12:17 PM

Item ID: D5338-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bushing
Start Date: 4/13/2017 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 4/18/2017 Req'd Qty: 40.00 ***40*** Customer:
Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: WA4	0.00							
130									
Packaging	Memo	0.00							
Packaging	*****STOCK IN BASKET CELL***** LOCATION : WA004								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

17/4/20 **98**

DAS
21
9-89
APR 19 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

Picklist Print

Friday, April 07, 2017 12:12:16 PM

Page 1

Work Order ID: 159303

159303

Parent Item: D5338-1

D5338-1

Parent Item Name: Bushing

Start Date: 4/13/2017

Required Date: 4/18/2017

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A NEW ISSUE 15-10-13 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			100	f	31.3250	0.041	1.726316			

M304R0.375

**

304 ROUND BAR 0.375

Location

Loc Qty

Loc Code

MAT028

31.325

m136790

7.325

m137175

24

m137263

DAS

45

9-89

174-15

3.5 ~~2.18~~

~~2.18~~

~~M303R0.375~~

~~m137263~~

~~Handwritten scribbles and signatures~~

DQA: _____ Date: _____

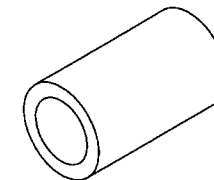
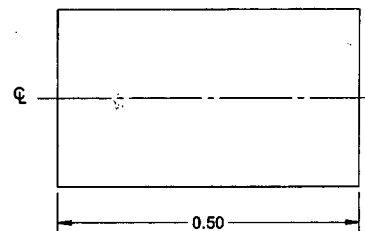
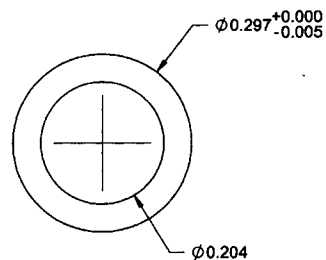


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 159303 ML5
170487

D5338-1 BUSHING

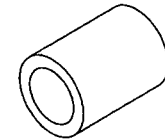
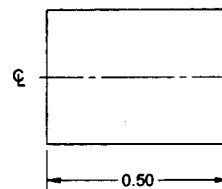
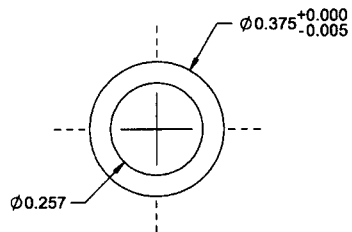
NOTES:

- 1) MATERIAL: AISI 303/304/316, STAINLESS STEEL ROUND BAR
PER ASTM A582 OR ASTM 276
(REF. DART SPEC M303R OR M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

RELEASE
2016-01-21
SCN 1506

APPROVED

A		NEW ISSUE		RF	15.08.10
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	RF				
CHECKED	AK	DRAWING NO.	REV. A		
MFG. APPR.	JLM	D5338	SHEET 1 OF 2		
APPROVED	HS	TITLE	SCALE		
DE APPR.	DS	BUSHING	NTS		
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D5338-3 BUSHING

NOTES:

- 1) MATERIAL: AISI 303/304/316, STAINLESS STEEL ROUND BAR
PER ASTM A582 OR ASTM 276
(REF. DART SPEC M303R OR M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

RELEASED
2016-01-21

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. A
MFG. APPR.	JLM	D5338	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BUSHING	NTS
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